

Order ID 53173

26, 2009 9:03:01 AM



Page 1

Item ID: D205-634-041

Accept



Setup Start



Revision ID: D

Stop



Item Name: Replacement Skidtube

Start Date: 26/10/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 10/11/2009 Req'd Qty: 1.00

Customer:

Reference:

Approvals:

Process Plan: *BS*

Date: *09/10/26*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D2580

Rev D

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy D205-634 bluefile & type labels per PPP D205-634-041 CHG002

NA

110

0.00



BENDING MACHINE - SKIDTUBES

CNC Bend 1

Memo

0.00

CNC Delta 100 Bender

1-Bend as per program D2580.C on CNC Bender and Folio FT009

2-Cut tubes as per Dwg. D2580

DP 9-10-28

Work Order ID 53173

October 26, 2009 9:03:01 AM



Page 2

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Item Name: Replacement Skidtube

Start Date: 26/10/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 10/11/2009 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

120

0.00



Skidtubes

Memo

0.00

Skidtubes

1- Deburr ends

2- C'sink holes as per dwg without cutting fluid

3- Prepare tube for welding, remove alodine as required.

4- Scribe batch number insied aft end of tube.

1 - - AWM 9-10-29

130

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

⇒ 50210121

④

p

Work Order ID 53173

October 26, 2009 9:03:01 AM



Page 3

Item ID: D205-634-041

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Item Name: Replacement Skidtube

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Start Date: 26/10/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 10/11/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:

Run Start



QC: Date: SPC (Y/N): Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

140

0.00



Skidtubes

Memo

0.00

Skidtubes

1-Weld step D2576 as per Dwg. D2580 and QSI 004
A/R□□□ Aluminum Rod

mill 999

BE 09/10/29

2-Prep per QSI 005 and weld crossbolt spacers D2579 as per Dwg. D2580, QSI 004.

For D2579 spacers, weld one side, pass 3/8" drill, weld other side, pass 3/8" drill
A/R□□□ Aluminum Rod

mill 999

BE 09/10/29

3-Grind welds as per Dwg D2580 Grind flush ridge made from bending

4-Drill holes for wearplates using DT 8217 & DT8937 Open holes to .19/64",
adjust stopper not to hit web. Deburr

5-Counterbore crossbolt spacers to 7/16" ID x 1.0" deep as per Dwg D2580.
Deburr holes

6-Drill pilot holes for aft cap using DT 8215 Open holes to 0.208". Deburr

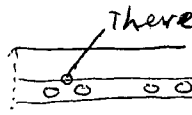
7-Drill pilot holes for Towing using DT8091, open to .640" and Deburr

BE 09/10/30

P10
9/28/09

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: D205-634-041 PAR #: _____ Fault Category: Skid tube NCR: (Yes) No DQA: / Date: 05.11.18
Resolution: rework Disposition: rework QA: N/C Closed: / Date: 05.11.18

NCR: <u>53173</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
05.10.30	140	Tube was slightly hit against the C-baring table when rotating the tube. The aft end rolled off of the plastic plating a tiny dent 0.010 deep x 0.040 wide on the corner edge of the ridge in between the 2 most aft skid tube holes.	<u>/</u> 05/11/18	Touch-up affected men with weld per Q21004; and grind flush re-work will not affect the x-bolt spacer.	<u>BE</u> 01/10/30	<u>S</u> 01/10/30	<u>/</u> 05/11/18	<u>/</u> 05.10.30
		skid ridge climbed the edge of the plastic support. Employee was not careful. R.C. Process. 	<u>/</u> 05/11/18	Be more cautious when placing / or moving parts.	<u>BE</u> 01/10/30	<u>S</u> 01/10/30	<u>/</u> 05/11/18	<u>/</u> 05.10.30

NOTE: Date & initial all entries

Work Order ID 53173

October 26, 2009 9:03:01 AM



Page 4

Item ID: D205-634-041

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Start Date: 26/10/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 10/11/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 QC Quality Control	QC10- Inspect visual per QSI004- ground welds Memo	0.00 2) 8 09/10/30 0.00				(X) /			
160 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 2) 8 09/10/30 0.00				(X) /			
170 HandFinish Hand Finishing	Pressure Wash per QSI005 4.3 Memo	0.00 MD 09/11/02 0.00				X/			

Work Order ID 53173

October 26, 2009 9:03:01 AM



Page 5

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Start Date: 26/10/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 10/11/2009 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

180

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

M 112148

Memo

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

2:35

320°

3:05

0.00

BR 09-11-2

①

190

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

= 7 min out 11/09

① X

Quality Control

Work Order ID 53173

October 26, 2009 9:03:01 AM



Page 6

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Stop



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Start Date: 26/10/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 10/11/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

200

0.00



HandFinish

Hand Finishing

Memo

0.00

1-Install inserts & wearplates & Gaskets as per Dwg. D2580. Use a drop of Sikaflex on insert holes before installing wearplates

A/R ☐ ☐ ☐ Sikaflex-291 ☐ M112391

Sikaflex expire date: 10/20

2-Coat D2594-3 O' rings with Petroleum Jelly and install on D2594-1 plugs as per Dwg D2580

3-Inspect for foreign object per QSI 024

4-Install 2855 Aft Cap as per Dwg D2580 and seal Fwd Step & Aft Cap with Sikaflex. Clean excess adhesive

A/R ☐ ☐ ☐ Sikaflex-291 ☐ M112391

Sikaflex expire date: 10/20

5-Wing Walk as per Dwg D2580 and QSI 005 4.4

Batch: M112106

(1X)

m-h 09/11/09

Work Order ID 53173

October 26, 2009 9:03:01 AM



Page 7

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Stop



Item Name: Replacement Skidtube

Start Date: 26/10/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 10/11/2009 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
210 	QC5- Inspect part completeness to step on W/O	0.00				<u>ml</u>	<u>09</u>	<u>11</u>	<u>09</u> ①
QC Quality Control	Memo Inspect Aft Cap, Fwd Step and Wing Walk of work to Current Step Inspect for Foreign objects per QSI 024	0.00							
220 	Packaging	0.00							
Packaging	Memo Identify and pack for shipping as per PPPD205-634-041 Location: _____ PPP Rev: _____	0.00							
230 	QC21- Final Inspection - Work Order Release	0.00							
QC Quality Control	Memo	0.00							

PPP 51500

9/11/10 50 (12)

09/11/10

MF
09-11-10

Picklist Print

October 26, 2009 9:03:05 AM

Page 1

Work Order ID: 53173

Parent Item: D205-634-041RevD

Parent Item Name: Replacement Skidtube

Start Date: 26/10/2009

Required Date: 10/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2580-1RevD		Manufactured	No			110	Each	0.0000	1.0000			
205 Skidtube bent detail												
D2576-3RevG		Manufactured	No			140	Each	169.0000	1.0000			
Step (maching detail)												

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

169

43504

21

46661

101

52215

47

D2579RevE

Manufactured

No

140

Each

695.0000

20.0000

Crossbolt Spacer

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

LG

573

51525

573

Main Warehouse

ST

122

43988

4

46434

4

46956

2

47797

9

48272

2

51314

71

51315

30

1 BE 09/10/29

20 BE 09/10/29

Picklist Print

October 26, 2009 9:03:05 AM

Work Order ID: 53173

Parent Item: D205-634-041RevD

Parent Item Name: Replacement Skidtube


Start Date: 26/10/2009

Required Date: 10/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2855RevA 		Manufactured	No			200	Each	106.0000	1.0000			
Cap												

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

FP6

106

50513

1

50770

5

51539 ✓

100

AN3-5A

Purchased

No

200

Each

2,249.000 2.0000



Bolt

Warehouse

Location

Loc Qty

Loc Code

Main Warehouse

ST

2249

100188

188

105057 ✓

2061

1x m-l 09/11/09

2x m-l 09/11/09

Picklist Print

October 26, 2009 9:03:05 AM

Work Order ID: 53173

Parent Item: D205-634-041RevD

Parent Item Name: Replacement Skidtube

Start Date: 26/10/2009

Required Date: 10/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN960JD10L		Purchased	No			200	Each	5,949.000	2.0000			
Washer												

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	5949	
101291	16	
104885	153	
105793	236	
109632	544	
110985	5000	

2x M. L 09/11/09

ALS7-1032-130

Purchased

No

200

Each

2,234.000 50.0000

Insert

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	2234	
105855	16	
108606	52	
111529	1488	
111779	313	
112772	365	

M110611

50x M. L 09/11/09

Picklist Print

October 26, 2009 9:03:05 AM

Work Order ID: 53173

Parent Item: D205-634-041RevD

Parent Item Name: Replacement Skidtube


Start Date: 26/10/2009

Required Date: 10/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN3C4A  BOLT		Purchased	No			200	Each	1,474.000	50.0000			

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	1474	
112314	13	
112720	12	
112724	3	
112794	846	
112829	500	
112991	100	

50x m-l 09/11/09

AN960C10L



washer

Purchased

No

200

Each

4,868.000 50.0000

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
OFFSHORE		
FG	100	
103585	100	
Main Warehouse		
ST	4768	
112116	876	
112612	2892	
112933	1000	

50x m-l 09/11/09

Picklist Print

October 26, 2009 9:03:05 AM

Work Order ID: 53173



Parent Item: D205-634-041RevD



Parent Item Name: Replacement Skidtube

Start Date: 26/10/2009

Required Date: 10/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3566-13RevC		Manufactured	No			200	Each	33.0000	1.0000			

Gasket

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
FP	31	
51606 ✓	31	
Main Warehouse		
ST	2	
45717	1	
50265	1	

1x m-p 09/11/09

Picklist Print

Page 6

October 26, 2009 9:03:05 AM

Work Order ID: 53173



Parent Item: D205-634-041RevD



Parent Item Name: Replacement Skidtube

Start Date: 26/10/2009

Required Date: 10/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3566-5RevC		Manufactured	No			200	Each	37.0000	1.0000			

Gasket

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
FP	12	
51929	12	
Main Warehouse		
FP19	21	
51669	1	
52909	20	
Main Warehouse		
ST	4	
36113	1	
46186	1	
47318	1	
51260	1	

IX M-L 09/11/09

Picklist Print

October 26, 2009 9:03:05 AM

Work Order ID: 53173



Parent Item: D205-634-041RevD



Parent Item Name: Replacement Skidtube

Start Date: 26/10/2009

Required Date: 10/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin. Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3566-1RevC		Manufactured	No			200	Each	26.0000	2.0000			

Gasket

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
FP	21	
52512 ✓	21	
Main Warehouse		
ST	5	
46349	1	
51218	1	
51259	3	

2x m-h 09/11/09

Picklist Print

October 26, 2009 9:03:06 AM

Work Order ID: 53173



Parent Item: D205-634-041RevD



Parent Item Name: Replacement Skidtube

Start Date: 26/10/2009

Required Date: 10/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3564-11RevD		Manufactured	No			200	Each	46.0000	1.0000			

Wearshoe

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
FP	11	
51905	11	
Main Warehouse		
FP19	33	
51594	10	
52125	23	
Main Warehouse		
ST	2	
45823	1	
50112	1	

1x m-l 09/11/09

Picklist Print

October 26, 2009 9:03:06 AM

Work Order ID: 53173

Parent Item: D205-634-041RevD

Parent Item Name: Replacement Skidtube

Start Date: 26/10/2009

Required Date: 10/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3564-13RevD		Manufactured	No			200	Each	56.0000	1.0000			
Wearshoe												

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
FP17	44	
51611	33	
52059	11	
Main Warehouse		
ST	12	
45409	2	
46495	10	

IX M-L 09/11/09

D3564-9RevD

Manufactured No

200

Each

10.0000

1.0000

Wearshoe

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
FP19	8	
51675	8	
Main Warehouse		
ST	2	
44659	1	
45825	1	

IX M-L 09/11/09

Picklist Print

Page 10

October 26, 2009 9:03:06 AM

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Start Date: 26/10/2009

Required Date: 10/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3564-5RevD		Manufactured	No			200	Each	37.0000	1.0000			
Wearshoe												

Warehouse	Loc Qty	Loc Code
Location		
OFFSHORE		
FG	2	
34806	2	
Main Warehouse		
FP19	18	
51655	10	
51925	8	
Main Warehouse		
ST	17	
45824	1	
47433	1	
52595	15	

1x m-10/11/09

D2594-3RevC

Manufactured No

200

Each

1,050.000 16.0000

O-Ring, 205 Skidtube

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
FP	50	
51613	50	
Main Warehouse		
ST	1000	
52562	1000	

16x m-10/11/09

October 26, 2009 9:03:06 AM

Shop Packet Print

Page 10

Picklist Print

Page 11

October 26, 2009 9:03:06 AM

Work Order ID: 53173



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Parent Item Name: Replacement Skidtube

Start Date: 26/10/2009

Required Date: 10/11/2009

Comments:

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Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2594-1RevC		Manufactured	No			200	Each	601.0000	16.0000			

Plug, 205 Skidtube

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	601	
42221	16	
42807	92	
43884	3	
46435	2	
51527	9	
51757	479	

16x M-1 09/11/09

DART**RELEASED**
07-06-28 #

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2580	REV. D SHEET 1 OF 3
DATE 07.02.27		TITLE 205 SKIDTUBE ASSEMBLY	SCALE NTS
A	96.09.16	NEW ISSUE	
B	96.12.02	AS MANUFACTURED	
C	98.08.26	REDRAWN, INCLUDED DEO 9094/9097	
D	07.02.27	CHANGE TO SS WEARPLATES AND GASKETS, INCLUDE DEO 9124/9183	

QTY -041	QTY -045	Part Number	Description
X		D2580-041	SKIDTUBE ASSEMBLY
	X	D2580-045	SKIDTUBE ASSEMBLY
1	1	D2500-1-190	EXTRUSION
1	1	D2576-3	STEP
20	24	D2579	CROSS BOLT SPACER
16	16	D2594-1	PLUG
16	16	D2594-3	O-RING
1	1	D2596	205 WEB
1	1	D2855	AFT CAP
1	1	D3564-5	WEARSHOE
1	1	D3564-9	WEARSHOE
1	1	D3564-11	WEARSHOE
1	1	D3564-13	WEARSHOE
2	2	D3566-1	GASKET
1	1	D3566-5	GASKET
1	1	D3566-13	GASKET
50	50	ALS7-1032-130 or AKS7-1032-130 or AKS4-1032-130 or AELS-1032-130	INSERT
50	50	AN3C4A	BOLT
2	2	AN3-5A	BOLT
50	50	AN960C10L	WASHER
2	2	AN960JD10L	WASHER

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 58173
09-10-20

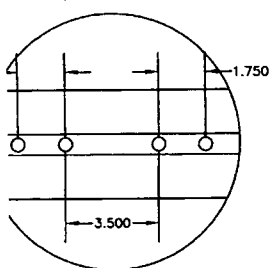
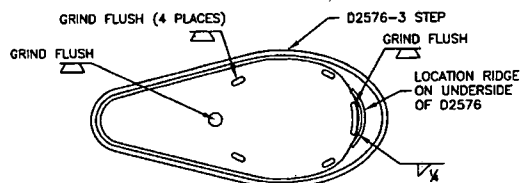
GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) INSERT D2596 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP.
- 4) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- 5) USE DART DRILL TEMPLATE TD2577-205 TO LOCATE AND DRILL Ø0.297 HOLES FOR WEARSHOE INSERTS. INSTALL ALS7-1032-130 PER SECTION D-D (50 PLACES) AFTER FINISH. INSTALL AN3C4A BOLTS AND AN960C10L WASHERS WITH SIKAFLEX-241/-291.
- 6) WELDING TO BE DONE PER DART QSI 004.
- 7) FINISH:
SEE NOTES ON
PAGE 2 FOR D2580-041 AND
PAGE 3 FOR D2580-045
- 8) INSERT D2594-1 PLUG C/W D2594-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER FINISH (16 PLACES).

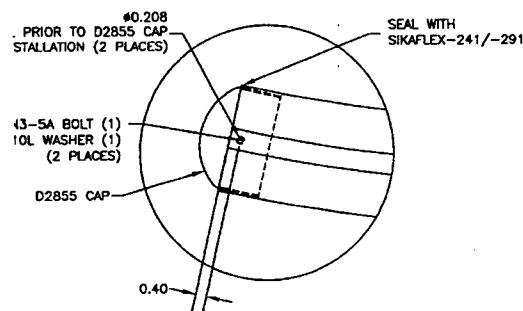
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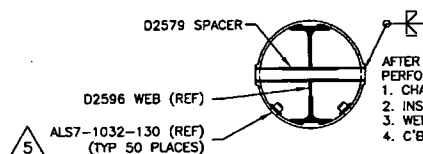
DETAIL A

**DETAIL B**

DETAIL C



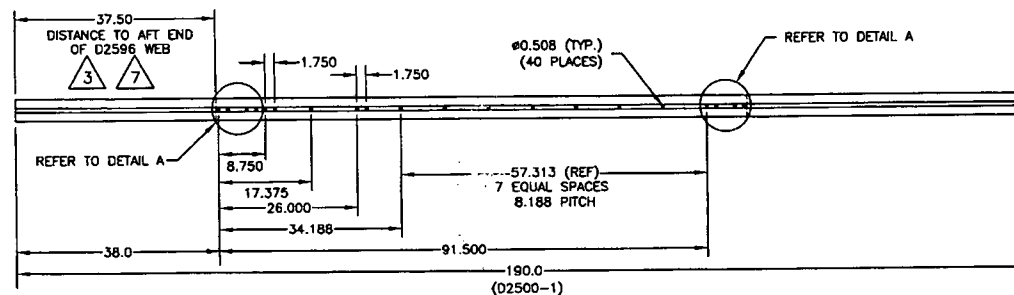
SECTION D-D



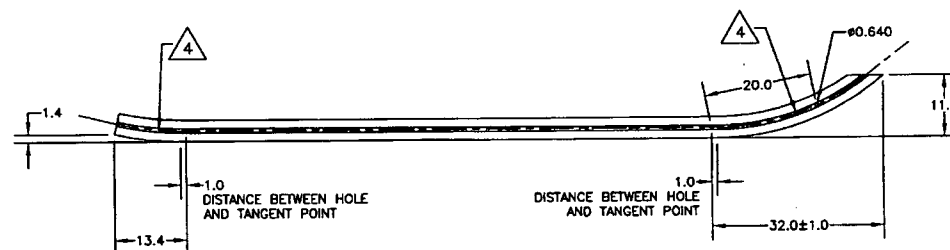
-041 NOTES

INISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB
POWDER COAT ASSEMBLY GLOSS WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4

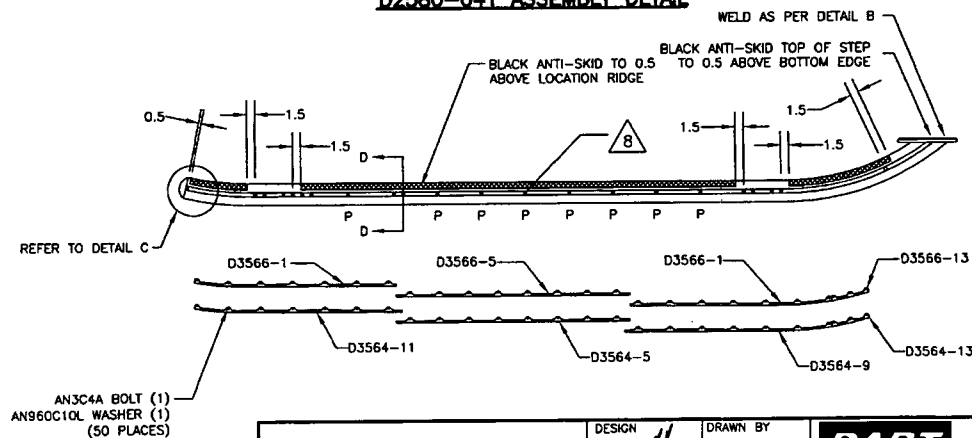
D2580-1 DRILLING DETAIL



D2580-1 BENDING AND CUTTING DETAIL



D2580-041 ASSEMBLY DETAIL



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DATE _____

DART

DART AEROSPACE LTD.
HAMPSHIRE, ONTARIO, CANADA

DRAWING NO.	
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REV. D

TITLE	
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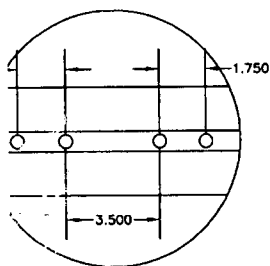
REV. D

SHEET 2 OF 3

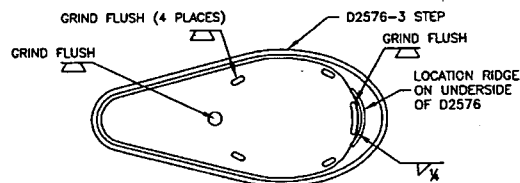
SCALE

1:24

SCALE 5:24

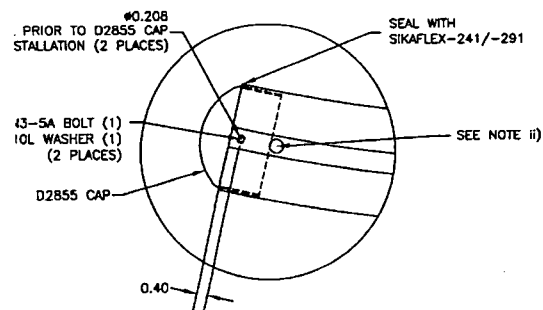


DETAIL F
SCALE 5:24

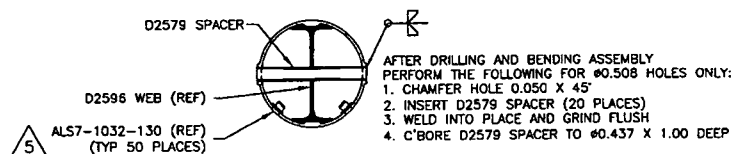


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07 Dec 28

DETAIL G
SCALE 5:24



SECTION H-H
SCALE 5:24

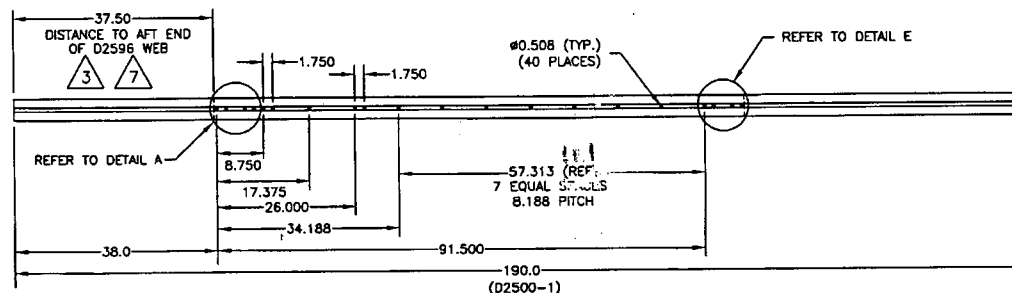


-045 NOTES

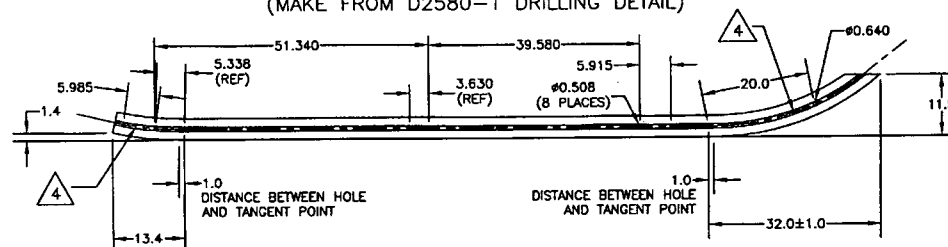
INISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB
POWDER COAT ENTIRE ASSEMBLY GREEN (REF. 4.3.5.8) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4

IT IS ACCEPTABLE TO GRIND A RELIEF IN THE D2855 AFT CAP TO PREVENT INTERFERENCE WITH THE SPACER AT THIS LOCATION

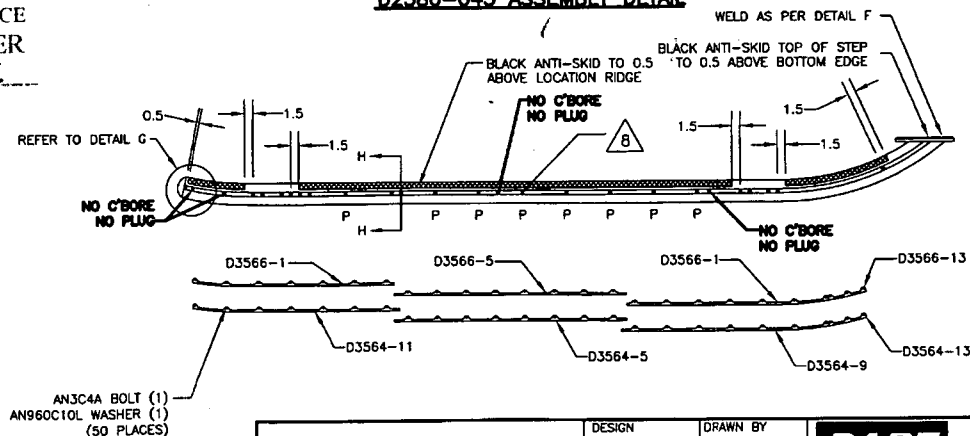
D2580-1 DRILLING DETAIL

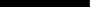




D2580-5 BENDING AND CUTTING DETAIL
(MAKE FROM D2580-1 DRILLING DETAIL)



D2580-045 ASSEMBLY DETAIL



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	P4 CHECKED 	P4 APPROVED 		DRAWING NO.	REV. D
	DATE	TITLE		SHEET 3 OF 3	SCALE
	07.02.27	205 SKIDTUBE ASSEMBLY		D2580	1:24

NO. 212

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barday Elliott
Job number: 51505
Part number: D205-634-041
Description: 205 skid tube
Welding Process: Tig~~h~~ Mig~~h~~ ☐
Base material: Aluminium
Current: AC~~h~~ ☐ DC~~h~~ ☐

TEST REQUIREMENTS AND RESULTS

Visual: pass~~h~~ ☒ fail~~h~~ ☐
Penetration: pass~~h~~ ☒ fail~~h~~ ☐

UNACCEPTABLE

Cracks: pass~~h~~ ☒ fail~~h~~ ☐
Undercut: pass~~h~~ ☒ fail~~h~~ ☐
Pin holes: pass~~h~~ ☒ fail~~h~~ ☐
Overlap (cold lap): pass~~h~~ ☒ fail~~h~~ ☐
Porosity (surface): pass~~h~~ ☒ fail~~h~~ ☐
Coloration: pass~~h~~ ☒ fail~~h~~ ☐

Qualifier Pat. D. Smith Date of Test Coupon 09.10.09

Welder Barday Elliott Date of Test Coupon 09-10-09

The above named individual is qualified in accordance with AWS D17.1.2001 to weld